



Dart Aerospace Ltd.
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K6A 1K7
Canada

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~~PRELIMINARY ISSUE~~

DAS
9
8-89

D5570-1
Job Sheet 181748

Accounting Job RD17-1048-01



POSITIVE
RECALL

Part No: D5570-1

Job Qty: 8 ea

Part Name: Blade Plug



Part Weight: 0 lbs

Status: Scheduled

Job Created: 8/7/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: DWG D5570-1 REV:A6 IPP REV:A NEW ISSUE 18/06/21 JFS VERIFIED BY:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE 18-09-04

Priority: Medium

@Rev A

ECW18017

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-4		
100	CNC Lathe	8 pcs	8/17/18	8/17/18	0.00	4.00	MORI NLX		
110	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-4		
120	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-4		
130	Packaging	8 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2		
140	QC21-SA	8 Ea	8/17/18	8/17/18	0.00	0.00	QC21		

Part Op 100 - ***Note***6.000" makes _____ pieces. 1-Machine as per DWG. & Folio FC158 FOLIO REV: GA DWG
Descriptions: REV: GA 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWR3.000-B	UHMW Rod (Round Bar), Black	1.3360 ft (.167 ea)	90-Start up Operation	508398

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWR3.000-B	1	3	0

Part Specifications

Specifications could not be found.



Container No: S102643



Part: D5570-1

Job No: 181748

Serial No/Batch: S102643

Revision: A6

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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www.dartaerospace.com

Plex 8/7/18 2:59 PM Dart.lajeunesse.marie

Date: 08/15/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

INSPECTION SHEET

DAS
38

9-89Date:Revised by

DQA: _____ Date: _____

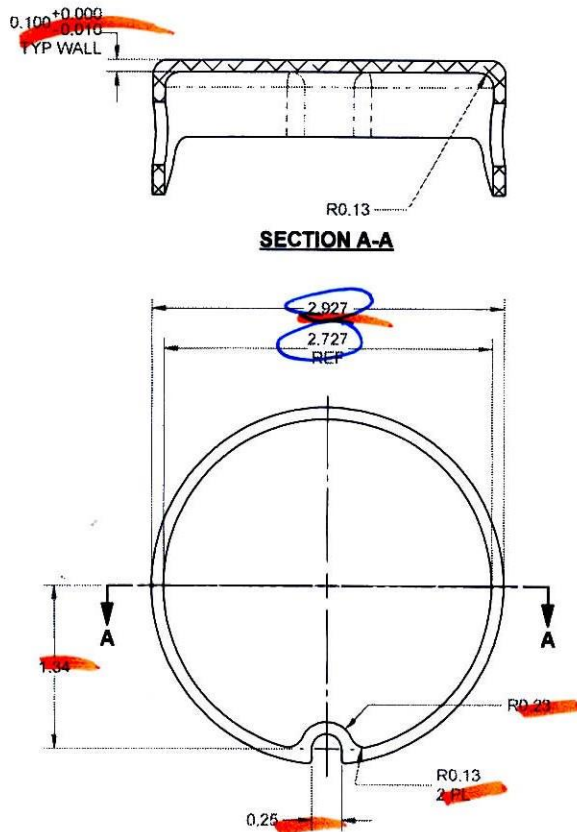


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

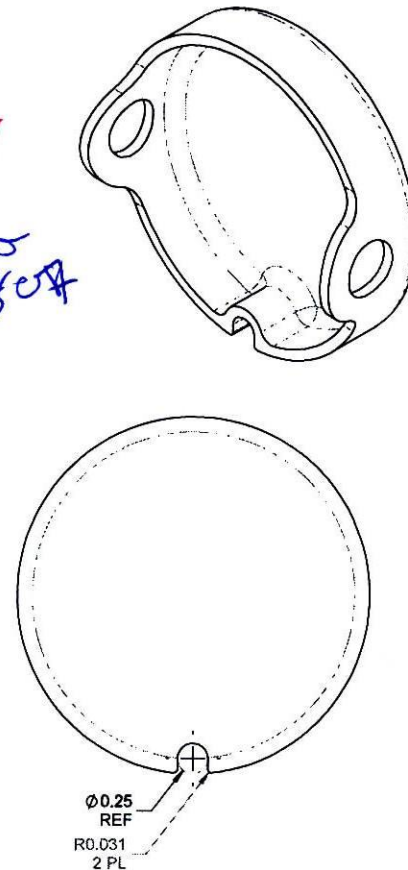
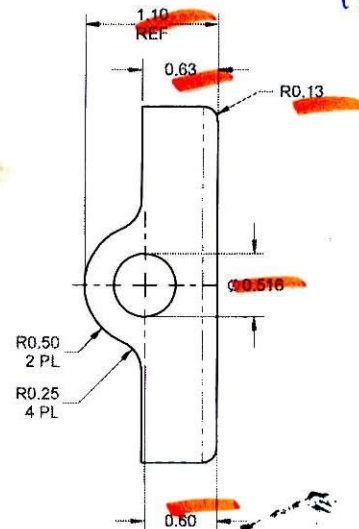


D5570-1 BLADE PLUG

NOTES:

- 1) MATERIAL: UHMW ROD (ROUND BAR), TIVAR 1000, COLOR BLACK
PER M-UHMVR-B
OR: UHMW SHEET, TIVAR 1000, COLOR BLACK
PER MUHMWB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.04 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 181748 MJS
180807



PRELIMINARY ISSUE

REV.	NEW ISSUE	DESCRIPTION	AJS	17.10.30
DESIGN	AJS		BY	DATE
DRAWN	NO			
CHECKED	ZF			
MFG. APPR.	JFS			
APPROVED				
DE APPR.				
DATE	17.10.30			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5570

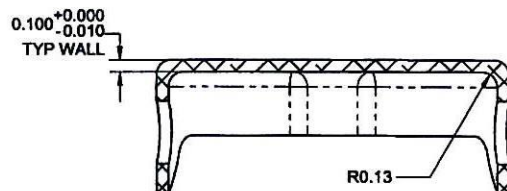
REV. A6

SHEET 1 OF 1

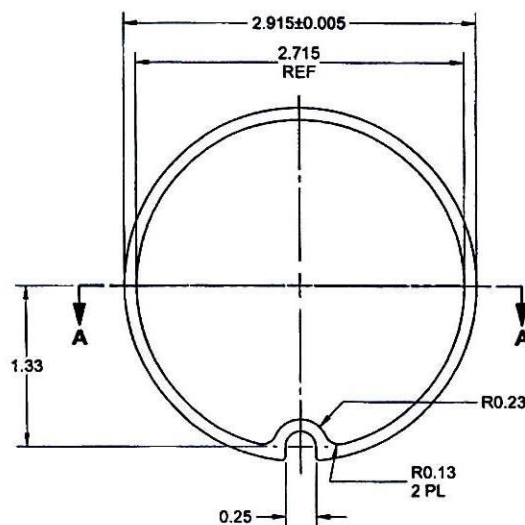
TITLE
BLADE PLUG

SCALE
NTS

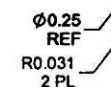
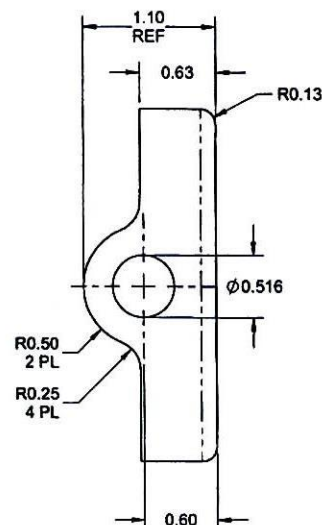
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SECTION A-A



D5570-1 BLADE PLUG



NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, ROUND BAR, COLOR BLACK
REF DART SPEC M-DELIN-R
OR
DELIN II 150E OR ACETRON GP ACETAL, BAR, COLOR BLACK
REF DART SPEC M-DELIN-B
OR
DELIN II 150E OR ACETRON GP ACETAL, SHEET, COLOR BLACK
REF DART SPEC M-DELIN-S
OR
UHMW ROD (ROUND BAR), TIVAR 1000, COLOR BLACK
REF DART SPEC MUHMWR
OR
UHMW SHEET, TIVAR 1000, COLOR BLACK
REF DART SPEC MUHMW
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED

2018 OCT 02
Ecn 18-817

APPROVED

REV.	NEW ISSUE	DESCRIPTION	ZF	17.10.30
DESIGN	AJS		BY	DATE
DRAWN	ZF			
CHECKED	MW			
MFG. APPR.	JFS			
APPROVED	NO			
DE APPR.	CP			
DATE	17.10.30			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5570** REV. A
SHEET 1 OF 1
TITLE **BLADE PLUG** SCALE NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>181748</u> Part No. <u>D 5570-1</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042) DAS 12 16/10/3 8.80 Completed By DAS 12 18/10/3 8.80	
Description Work Order Deviation				Disposition			
Plugs manufactured to OD = 2.927 ± 0.01 actual dims 2.929 per Rev A6 Rev A dim 2.915 ± 0.01				Acceptable as is. Not structural.			
				Lead hand / Supervisor 			
				QC / QA Coordinator 			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					